

5/44

DART AEROSPACE LTD	Work Order:	24593
Description: Extrusion	Part Number:	100 D2500-1-190
Drawing: D2500 Rev. F1	Qty:	100

Step	Location	Procedure	By	Date	qty
1	DC	Issue Traveller	U	05/10/18	100
2	PG	Issue P/O: <u>2008841</u> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long 100" g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	AP	05/10/19	100
3	RG	Inspect for transit damage Ensure certification are attached	CL	05/11/01	99
4	QC6	Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester	J	05-12-21	55
5	ST	Identify & stock	J	05-12-21	59
6	AC	Cost / part	J	06/05/18	99
7	DC	Close W/O Inspect level 21	J	06/05/18	99

Rev	Date	Change	Revised By	Approved
E	01.03.29	Changed part number to -190	EC	
F	01.10.29	Revised Step 2	SM	
G	02.09.05	Added DSK 066	KJ	

RELEASED
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/05/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>DIB</i>	DRAWN BY <i>DIB</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DIB</i>	DRAWING NO. D2500	REV. F SHEET 1 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE NTS
A	96:03:19	NEW ISSUE	
B	96:03:24	CHANGE INTERNAL WEB	
C	96:04:26	ADD D2500-3 WEB	
D	96:10:07	ADD MATERIAL PROPERTIES	
E	96:10:24	CHANGE MATERIAL TEMPER	
F	97:09:29	CHANGE MAT. TO 6061-T6	
FI	01.04.17	ADD NOTES 4 & 5 <i># UP</i>	

RELEASED
97/10/06 DS

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
TO ENSURE THAT THE BATCH MEETS THE ABOVE
MINIMUM MECHANICAL PROPERTIES.

SHOP COPY

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WITHOUT NOTICE

2. BREAK ALL SHARP CORNERS 0.010 MAX

WORK ORDER

NO. 24593

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)

D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # 897105 → PREFERRED

b) CARADON MIDWEST DIE # PAH-28030

c) CARADON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)

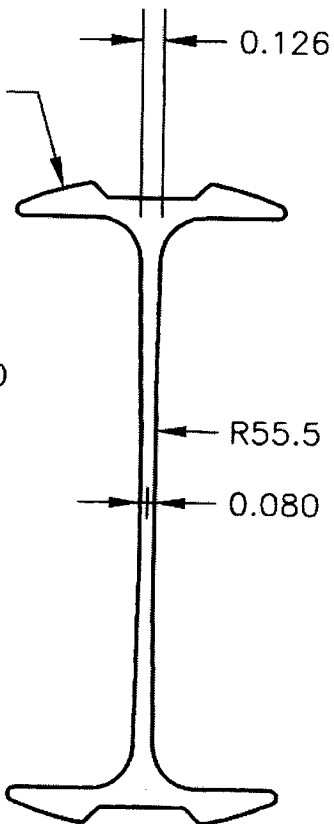
D2500-3 EXTRUSION MANUFACTURED FROM CARADON INDALEX DIE # MS-18867

DART

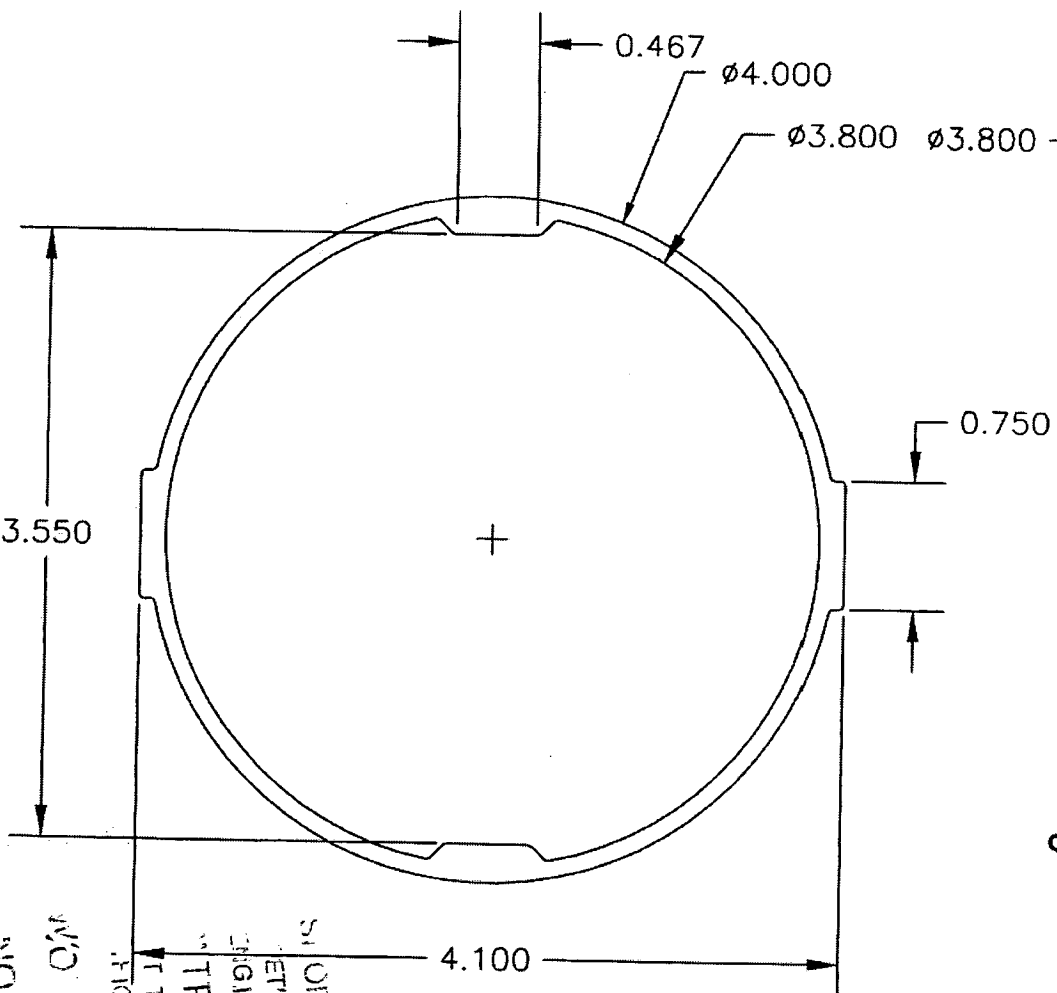


DESIGN	<i>MB</i>	DRAWN BY	<i>MB</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	<i>MB</i>	APPROVED	<i>MB</i>	DRAWING NO.	D2500
DATE	97:09:29	TITLE	EXTRUSION	REV. F	SHEET 2 OF 2
				SCALE	1:1

RELEASED
47/10/06 05

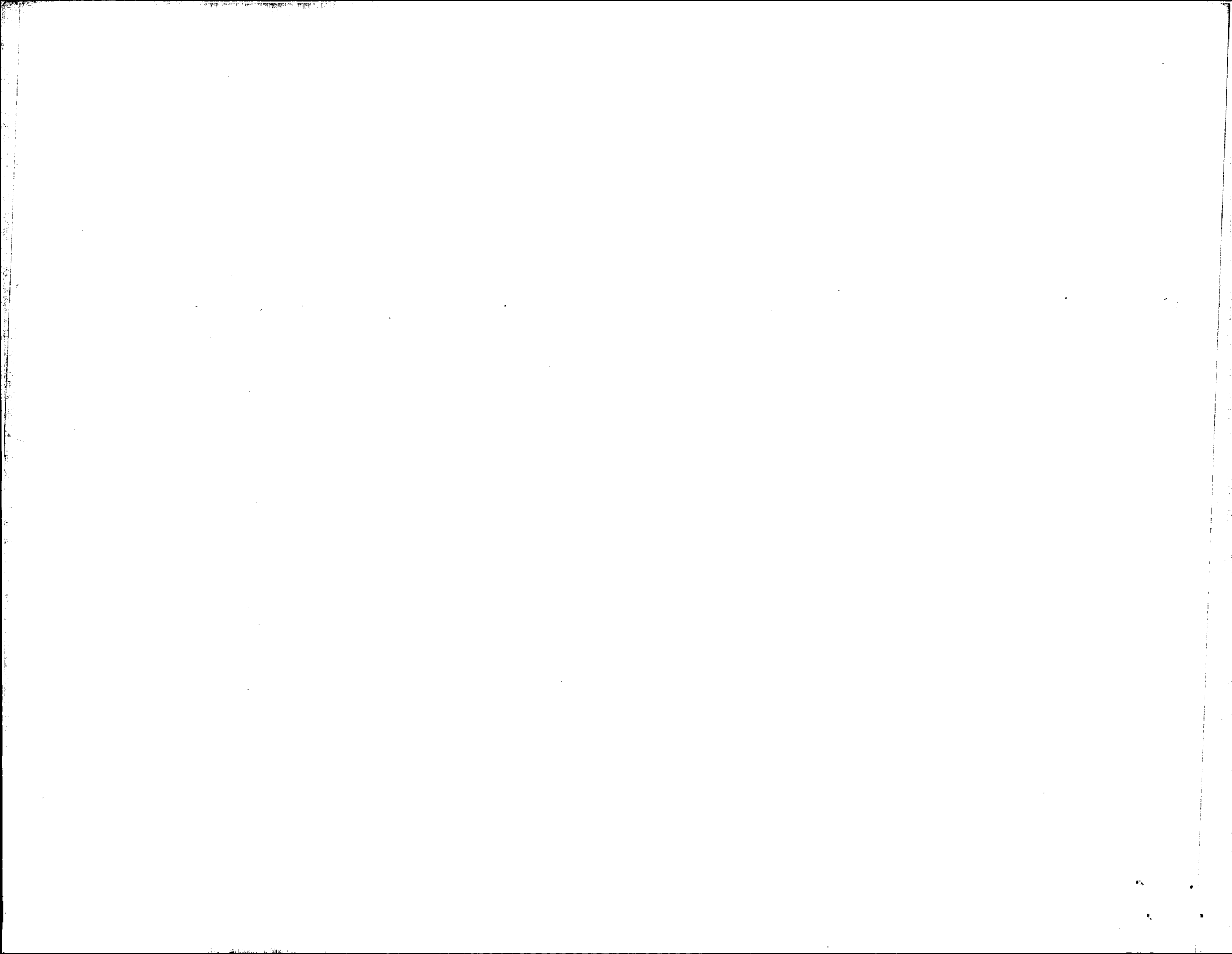


D2500-3



D2500-1

NO. OF COPY
RETURN TO
ENGINEERING
STRONG COPY
ATTN: JIC
NO. 24593



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
11:00 am

Work Order No : 0024593
Project Name : D2500-1-100
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2500-1-100
Description : Skidtube Extrusion
Manufactured : No
Amount Req'd : ~~0.00~~
Amount Done : 0
Start Date : 10-18-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

**BON L CANADA INC**1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert. Date	Cert. No.	Sales Order	Page
10/31/05	129811	73945	1
Cust. PO	B/L No.	Lot	Date
2008841	00283102	73945010	10/31/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897105-3	100" MILL 6061 T6	D2500-1-100
Gross Weight	1517 LBS		
Net Qty	1,451 LB	99 PC	825 FT 5 PKG
Specification	ASTM B221-00		
		Die Desc	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	300.0 / 43.5	280.6 / 40.7	8.1	.0	95

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	ZR	OTHER
MIN:	.400	.000	.150	.000	.800	.040	.000	.000	.000	EA: .050
MAX:	.800	.700	.400	.150	1.200	.350	.250	.150	.050	TOT: .150

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada